

Work Order ID 82681

82681

Page 1

April-04-12 7:57:42 PM

Item ID: D350-636-011

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube LH

Stop *NS2*

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 12/04/05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

5/11/05
JB

ML5 12-5-2

B 82681 R+1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 82681***82681***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 04/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 1.00

1

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

110

Skidtubes

Skidtubes

Skidtubes

0.00

0.00

Memo

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D27503- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr. ✓4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade
fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) ✓7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ✓
SECOND SIDE8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail C to 0.500" (8 holes per side) ✓9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297". ✓

10-Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

120419

W/O:		WORK ORDER CHANGES					
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Tooling:

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch:

m120854 BE 12/04/19
→ CF 12/4/19

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 12/221
exp. date: 13/01/04

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M120104
M120854

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

->

CF

12-4-25

DC 12/04/23

- DC 12/04/23

3BE 12/04/24

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Debur holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

OK/CC 12-4-25

8.1765101

8.1765101

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Run Start ***NR1***

Stop ***NR2***

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190 Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

Handwritten: 12-5-1

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 1:00, 320 OF, 1:30

Handwritten: 12/05/01

210 QC7-Inspect Chemical Conversion Coat

0.00

210

QC

Quality Control

Memo

Inspect for foreign object per QSI 024

Handwritten: 12/05/02

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 Required Date: 18/04/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>N/A</u>								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>11121271</u>								
	EXP DATE: <u>13/6/12</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>N/A 110349</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>N/A 114596</u>								

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

270

Packaging

Packaging

0.00

Reo I

Memo

0.00

Packaging

Package as per PPP D350-636-011

280

280

QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

12/5/03
MLW 12/05/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	46.0000	8	8			
D3492-1									**			12/11/05/10/2	
Plug													

Location

Loc Qty

Loc Code

FP002

46

1383098

12

69531

8

74444

2

76235

4

77037

32

D3492-3		Manufactured	No			230	Each	1.0000	8	8			
D3492-3									**			12/11/05/10/2	
Plug													

Location

Loc Qty

Loc Code

FP-A

1

78600

1

1383099

12

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH

82681

D350-636-011

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

275.0000

8

8

NAS1611-010

O-RING

**

YU 12/05/02

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

225

110915

14

117460

8

118077

1

118612

3

119438

47

120986

50

121166

52

121259

50

X 8

NAS1149D0863J

Purchased

No

250

Each

219.0000

2

2

NAS1149D0863.J

WASHER

**

JB 12/05/02

Location

Loc Qty

Loc Code

ST298

219

118078

36

119307

83

120308

100

119307

D2744

Manufactured

No

110

Each

46.0000

1

1

D2744

Cap

**

04/04/19

Location

Loc Qty

Loc Code

LG002

46

62715

1

70881

3

78900

42

1

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Shop Packet Print

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D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110 Each

15.0000 1 1

D2600-3-BENT

Extrusion Bent

~~B 883305~~ B 883305

**

① 12-04-18

Location

Loc Qty

Loc Code

LG

15

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

D2743

Manufactured No

160 Each

346.0000 8 8

D2743

Crossbolt Spacer

**

[Signature]

BE 12/04/24
B 881965 v8

Location

Loc Qty

Loc Code

LG001

346

67766

4

68251

3

73403

64

74445

1

78603

2

79517

62

D2739

Manufactured No

160 Each

5.0000 1 1

D2739

350 I Beam

**

12/04/23

Location B 882124

Loc Qty

Loc Code

LG

5

72155

1

81508

1

82122

3

①

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D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 90.0000 4 4

D3490-3

Cross Bolt Spacer

**

BB 12/04/24

Location

Loc Qty

Loc Code

LG

88

82016

88

LG001

2

78800

2

D3490-1 Manufactured No

160 Each 124.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 12/04/24

Location

Loc Qty

Loc Code

LG

115

81976

115

LG001

9

62450

2

74875

4

77042

3

ALS4-1032-225 Purchased No

220 Each 2,477.000 38 38

ALS4-1032-225

Insert

**

AL 11/05/10 2

Location

Loc Qty

Loc Code

ST281

2454

108696

146

110768

62

118386

55

118966

68

120671

123

121269

2000

ST282

23

120410

10

120451

13

X38

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Shop Packet Print

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Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

30.0000

1

1

D3793-3

Wearshoe

**

Sl 12/05/02

Location

Loc Qty

Loc Code

FP001

23

80434

11

82166

12

FP002

7

78935

7

X1

AN8C35A

Purchased

No

230

Each

56.0000

1

1

AN8C35A

BOLT

**

Sl 12/05/02

Location

Loc Qty

Loc Code

FP002

55

115960

1

117834

8

118286

46

ST346

1

114442

0

115188

0

115960

1

X1

D3793-1

Manufactured

No

230

Each

26.0000

1

1

D3793-1

Wearshoe

**

Sl 12/05/02

Location

Loc Qty

Loc Code

FP001

26

78901

10

82171

16

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

11.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

24 12/05/02

Location

Loc Qty

Loc Code

FP002

11

1382271

X1

61689

1

75056

2

77021

8

D3794-3

Manufactured No

230

Each

23.0000

1

1

D3794-3

Gasket

**

24 12/05/02

Location

Loc Qty

Loc Code

FP002

23

74530

2

80436

21

X1

AN6C44A

Purchased No

230

Each

175.0000

4

4

AN6C44A

BOLT

**

24 12/05/02

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

173

120143

25

120465

27

120641

1

121013

20

121167

100

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

115.0000

1

1

MS21083C8

NUT

41 12/05/02

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

D3536-25

Manufactured

No

230

Each

22.0000

1

1

D3536-25

Gasket

41 12/05/02

Location

Loc Qty

Loc Code

FP

14

81342

14

FP002

8

78902

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3631-1

Manufactured No

230

Each

243.0000

8

8

D3631-1

**

Washer

LocationLoc QtyLoc Code

FG

100

81874

100

ST072

143

68062

2

75548

141

X8

D3791-1

Manufactured No

230

Each

9.0000

1

1

D3791-1

**

Wearplate

LocationLoc QtyLoc Code

FP002

9

62239

2

78897

7

B82168

V1

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

*AN960C10L *

washer

M121509

**

D2745

Manufactured No

230

Each

64.0000

8

8

D2745

**

Bushing

LocationLoc QtyLoc Code

FP

62

79518

62

FP001

2

69529

1

76142

1

B81961

V8

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Page 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,602.000

34

34

AN3C5A

Bolt

**

HL nlosloz

Location

Loc Qty

Loc Code

FP001

7

11121068

x34

115835

7

ST350

1595

116419

28

117343

13

117764

7

117872

2

119749

23

120423

522

1210168

500

121255

500

D3537-1

Manufactured

No

230

Each

26.0000

3

3

D3537-1

Wearpad

**

HL nlosloz

Location

Loc Qty

Loc Code

FG

10

79833

10

1381959

x3

FP002

16

69817

5

80337

11

NAS1149C0832R

Purchased

No

230

Each

295.0000

1

1

NAS1149C0832R

WASHER

**

HL nlosloz

Location

Loc Qty

Loc Code

ST297

295

114915

295

x1

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

517.0000

4

4

AN3C6A

BOLT

**

11 11/05/02

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

516

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

27

120693

400

4

NAS1611-013

Purchased

No

230

Each

250.0000

8

8

NAS1611-013

O-RING

**

11 12/05/02

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

11121584

X3

X3

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Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

22.0000

1

1

D3535-25

Wearshoe

**

24 12/05/02

Location

Loc Qty

Loc Code

FP001

22

62233

1

80331

10

81357

11

X1

D3794-1

Manufactured No

230

Each

16.0000

1

1

D3794-1

Gasket

**

24 12/05/02

Location

Loc Qty

Loc Code

FP002

16

75042

4

80435

12

B82167

VS

MS21043-6

Purchased No

230

Each

773.0000

4

4

MS21043-6

NUT

**

24 12/05/02

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

753

112314

47

117887

6

118384

200

120308

500

X4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

54.0000

2

2

✓

D3493-1

**

JB

Washer

Location

Loc Qty

Loc Code

ST050

54

70697

2

77573

12

78835

40

78835

Purchased

No

250

Each

115.0000

2

2

✓

MS21083C8

MS21083C8

**

121524 JB 12/05/02

NUT

Location

Loc Qty

Loc Code

304

50

121185

50

FP002

1

115884

1

ST303

6

115884

0

118077

1

119309

2

119436

1

119638

2

ST304

58

120142

8

120731

25

121011

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 82681

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

82681

D350-636-011

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

79.0000

2

2

✓

**

AN8C21A
BOLT

Location

Loc Qty

Loc Code

ST343

79

118758

5

120094

34

121067

20

121167

20

121067

NAS1515H3L

Purchased

No

230

Each

198.0000

4

4

**

***NAS1515H3I ***
WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

158

118686

3

119438

1

120072

8

120360

96

121243

50

XJ

D2741

Manufactured

No

250

Each

67.0000

1

1

✓

**

D2741
Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

77

71856

1

76984

26

79516

40

79516

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Page 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 14

Work Order ID: 82681

82681

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

55.0000

2

2

D3532-1

Spacer

**

gB

12/05/02

Location

Loc Qty

Loc Code

ST053

55

78839

31

82041

24

82041

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (ϕ 0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82681 MLJ
12/04/05

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.

PORT HADLOCK, WA

DRAWING NO.

D2750

REV. F

SHEET 1 OF 11

TITLE

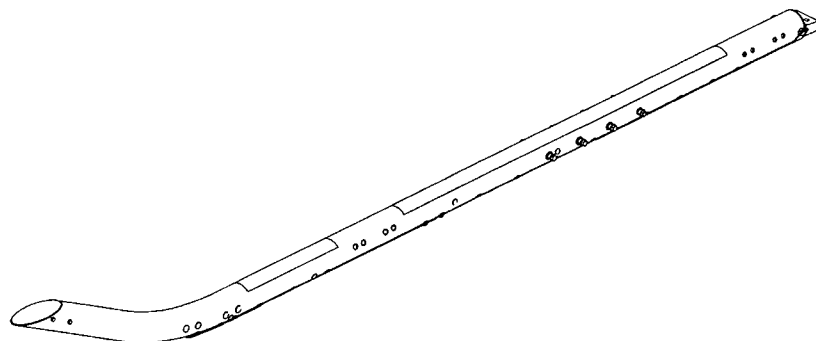
350 SKIDTUBE ASSEMBLY

SCALE

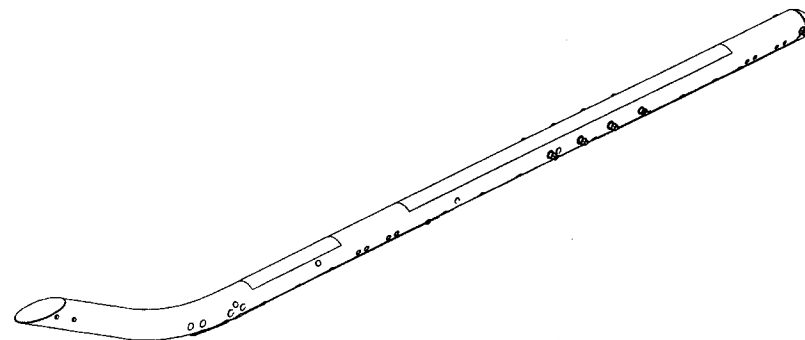
NTS

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82681



D2750-041 350 SKIDTUBE ASSEMBLY, LH

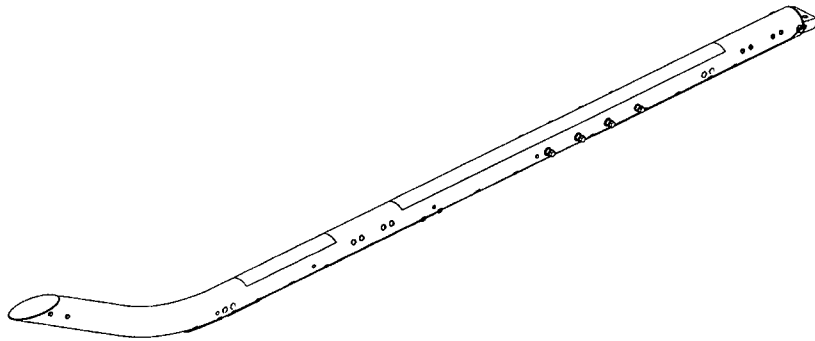


D2750-042 350 SKIDTUBE ASSEMBLY, RH

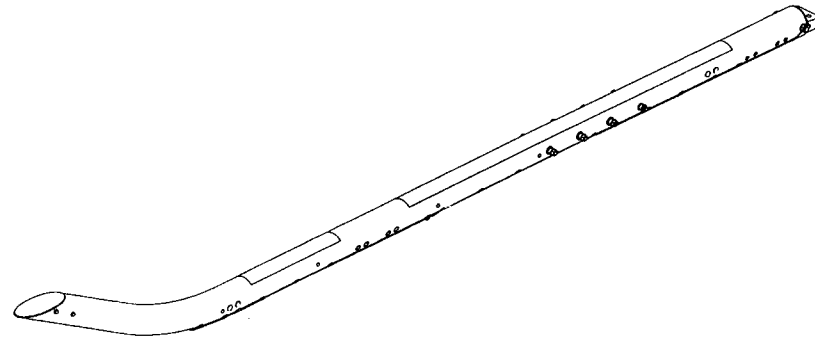
RELEASED
15 JUL 1994

DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	PC	PORT HADLOCK, WA	
CHECKED	PC	DRAWING NO.	REV. F
MFG. APPR.	PC	D2750	SHEET 2 OF 11
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	350 SKIDTUBE ASSEMBLY	NTS
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82681



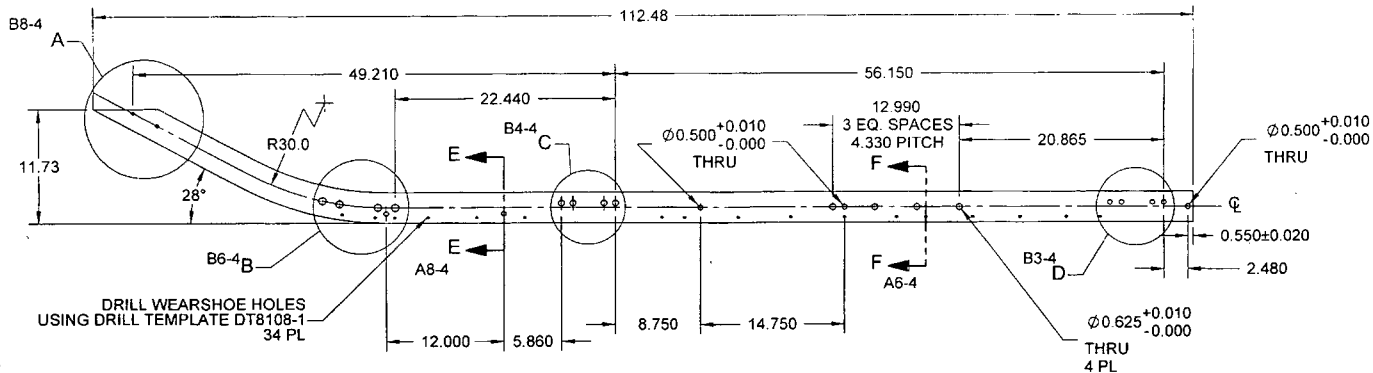
D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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68-09-22/100

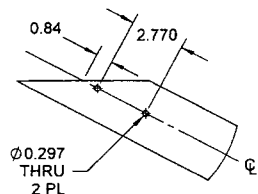
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	DA	D2750	SHEET 3 OF 11
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	350 SKIDTUBE ASSEMBLY	NTS
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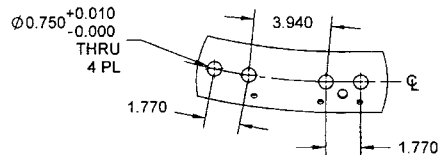
02681

(F)

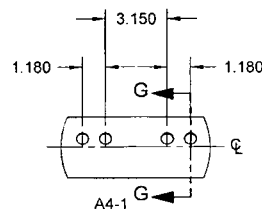
D2750-1 LH SKIDTUBE



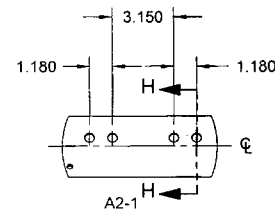
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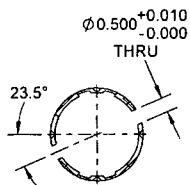
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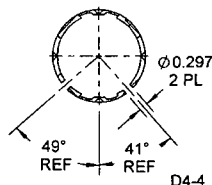
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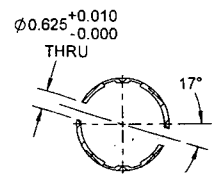
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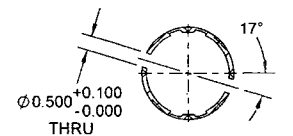
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

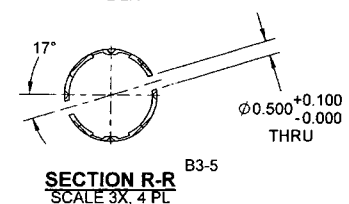
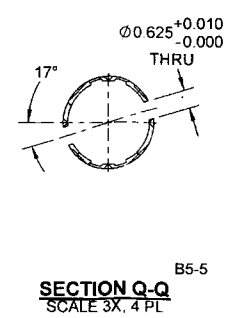
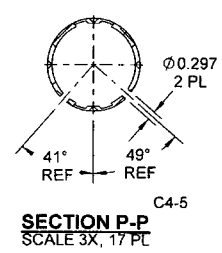
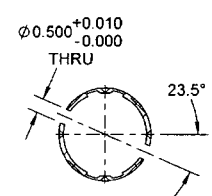
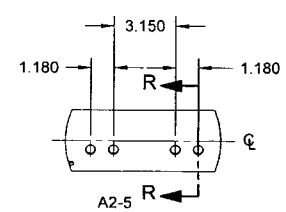
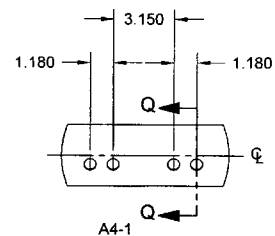
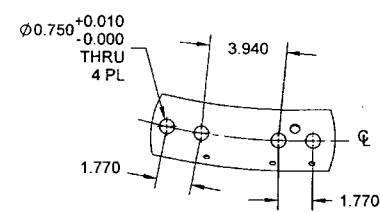
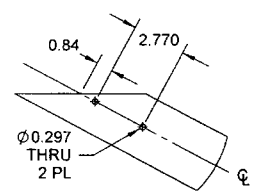
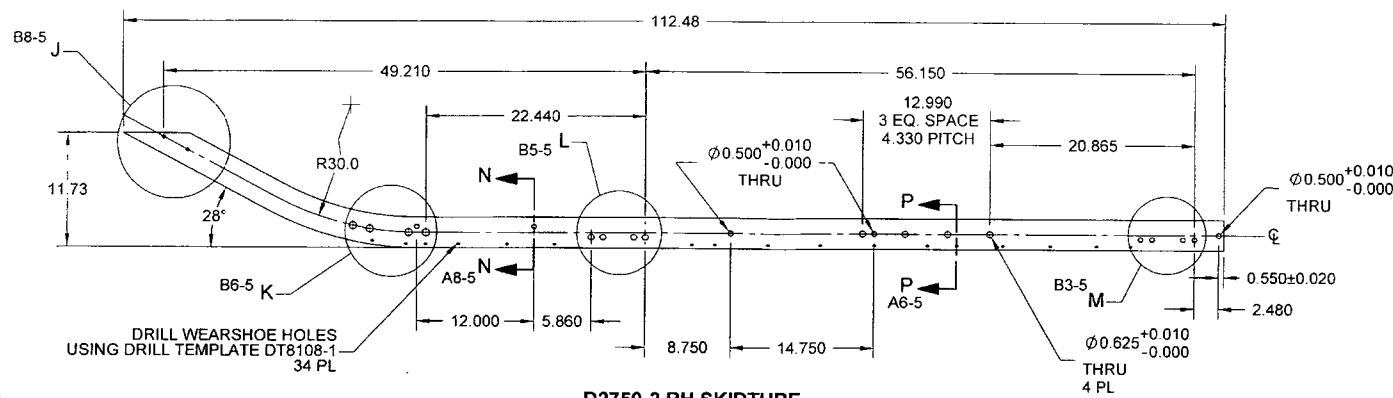


SECTION H-H
SCALE 3X, 4 PL

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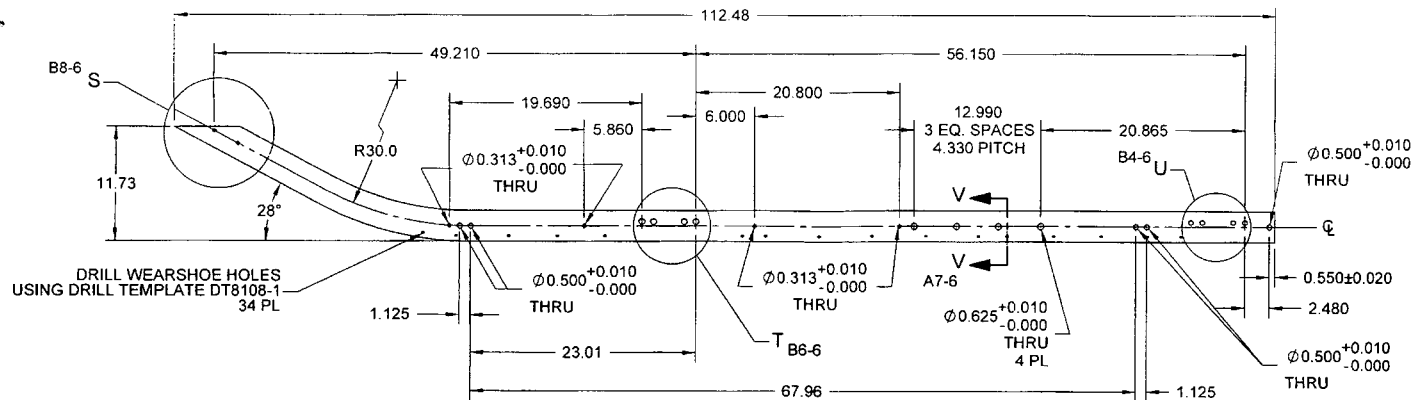
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MFG. APPR.		D2750	SHEET 4 OF 11
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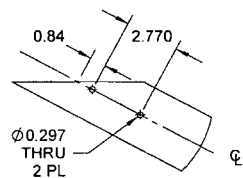


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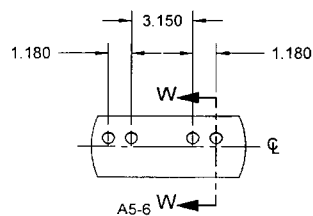
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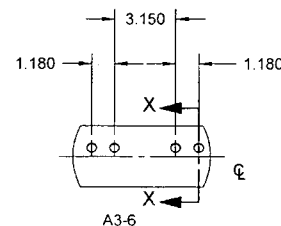
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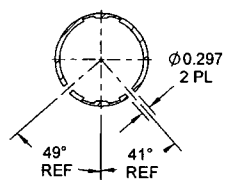
DETAIL S
D8-6
SCALE 2X



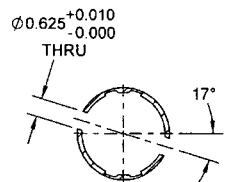
DETAIL T
C5-6
SCALE 2X



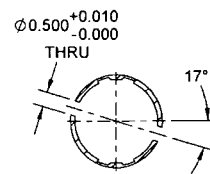
DETAIL U
D3-6
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL




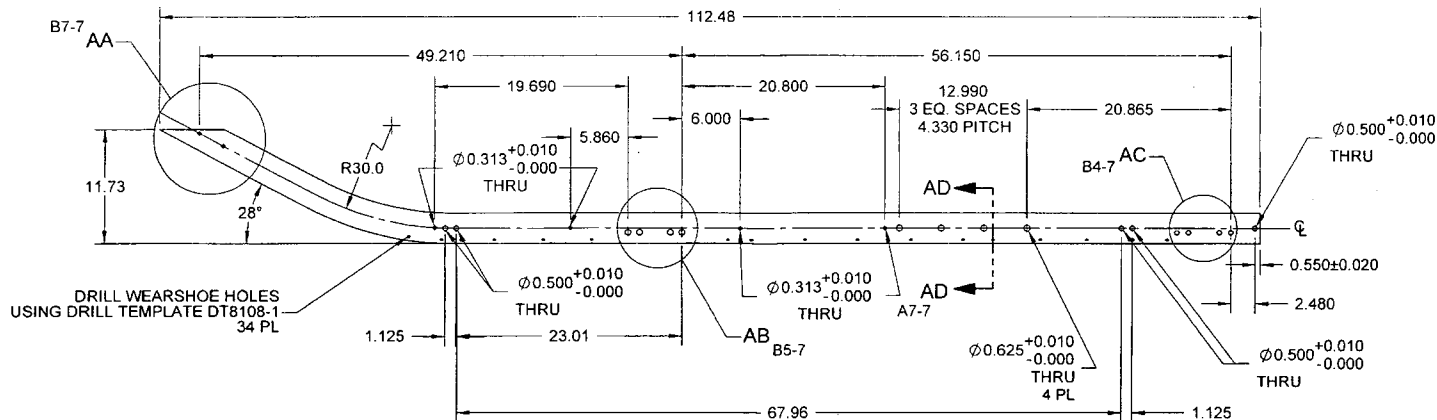
SECTION W-W
SCALE 3X, 4 PL



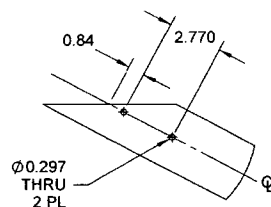
SECTION X-X
SCALE 3X, 4 PL

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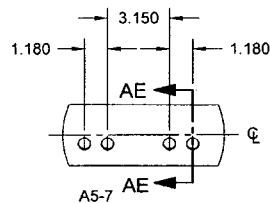
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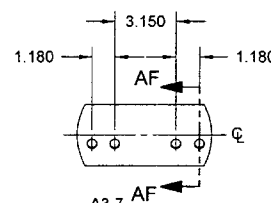
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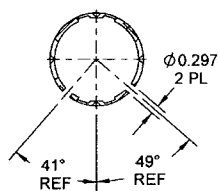
DETAIL AA
SCALE 2X
D7-7



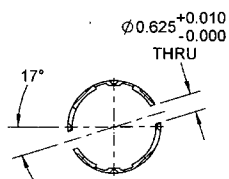
DETAIL AB
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C4-7



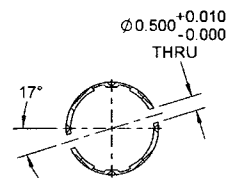
DETAIL AC
SCALE 2X
D3-7



SECTION AD-AD
SCALE 3X, 17 PL
D3-7



SECTION AE-AE
SCALE 3X, 4 PL
B6-7

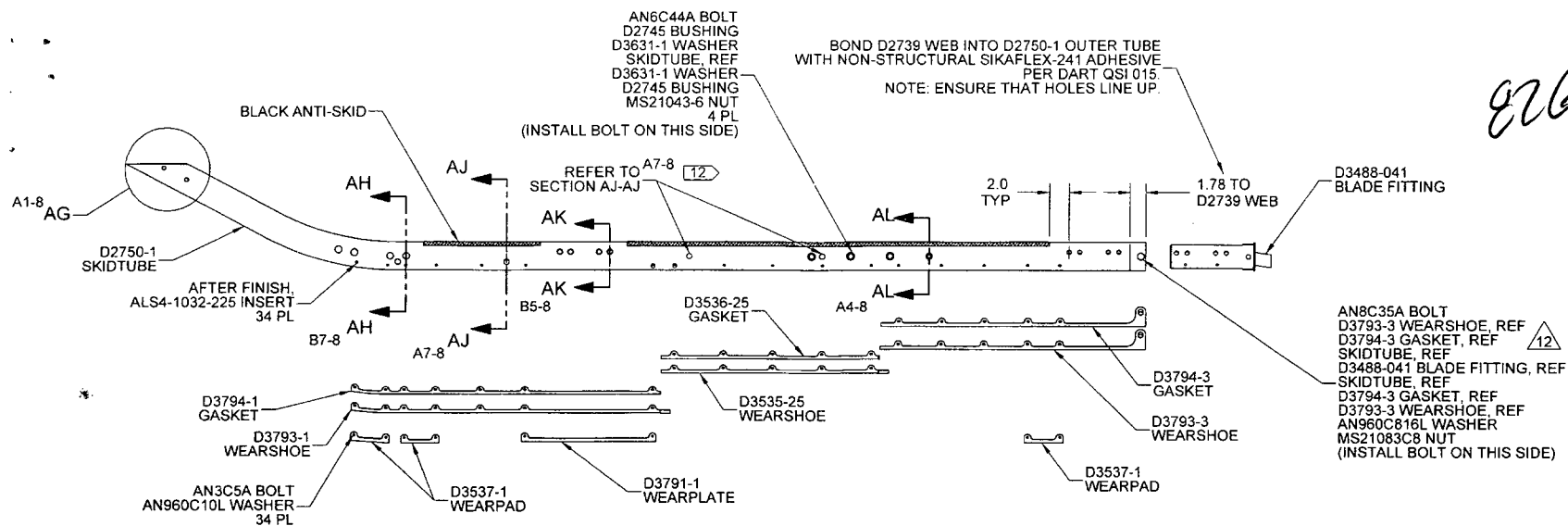


SECTION AF-AF
SCALE 3X, 4 PL
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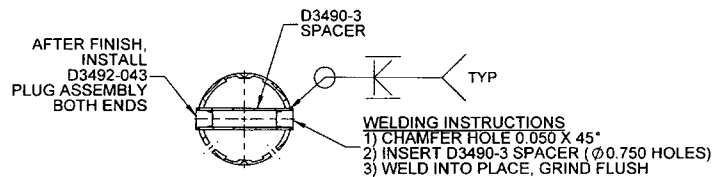
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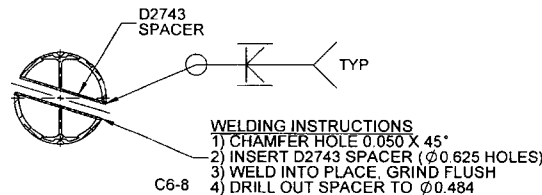
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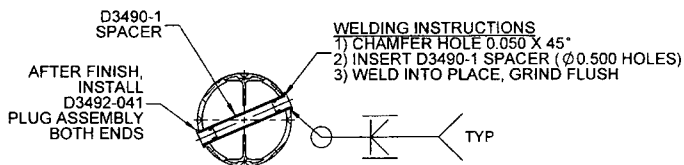
D2750-041 350 SKIDTUBE ASSEMBLY, LH



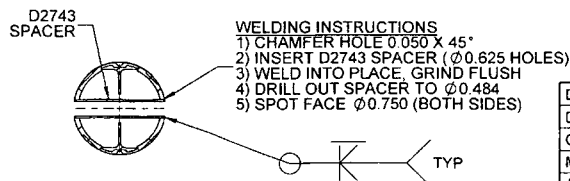
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SCALE 3X, 4 PL



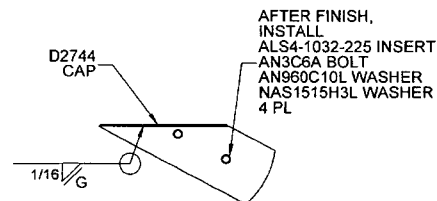
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SECTION AJ-AJ
SCALE 3X, 4 PL



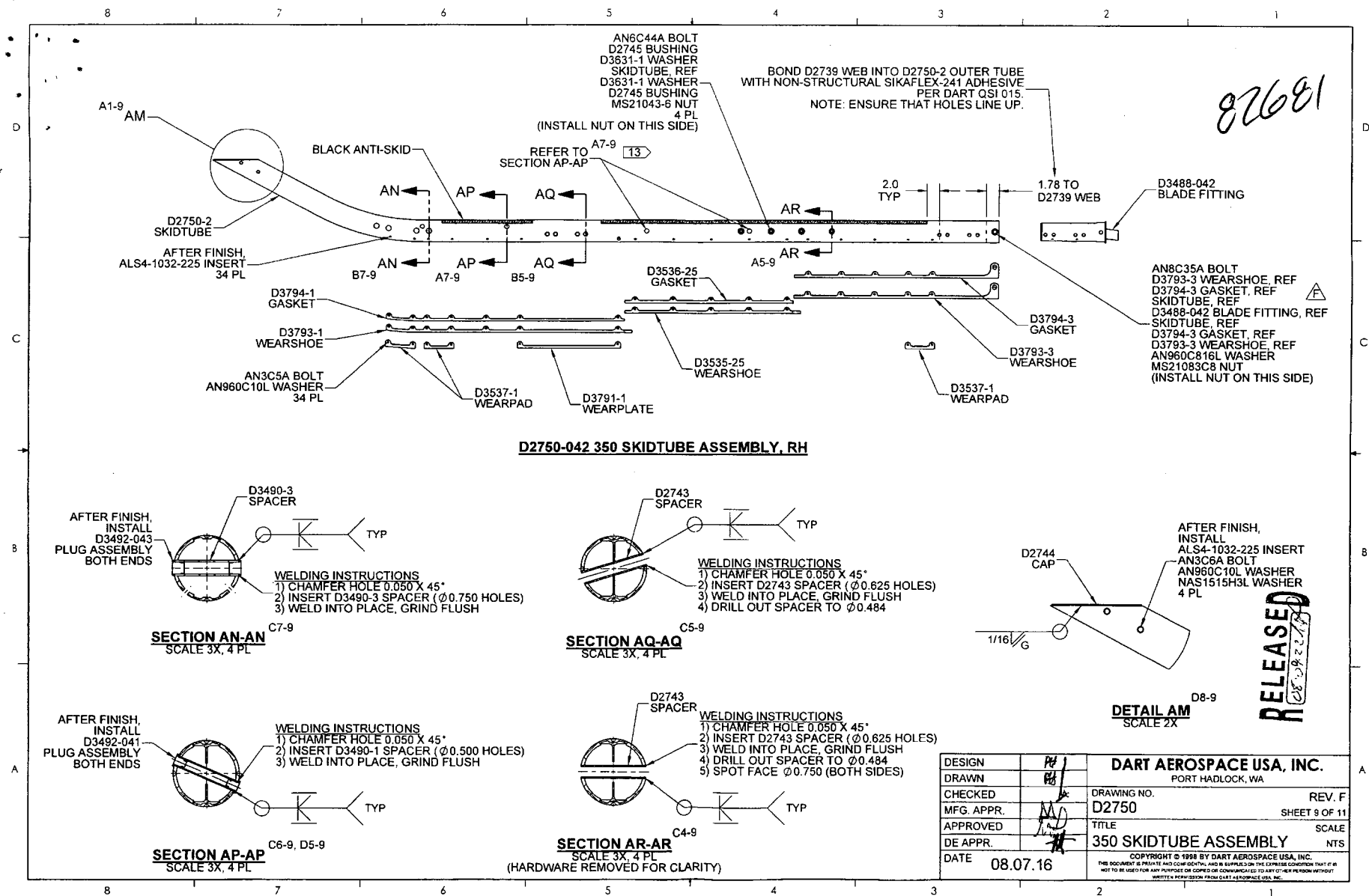
SECTION AL-AL
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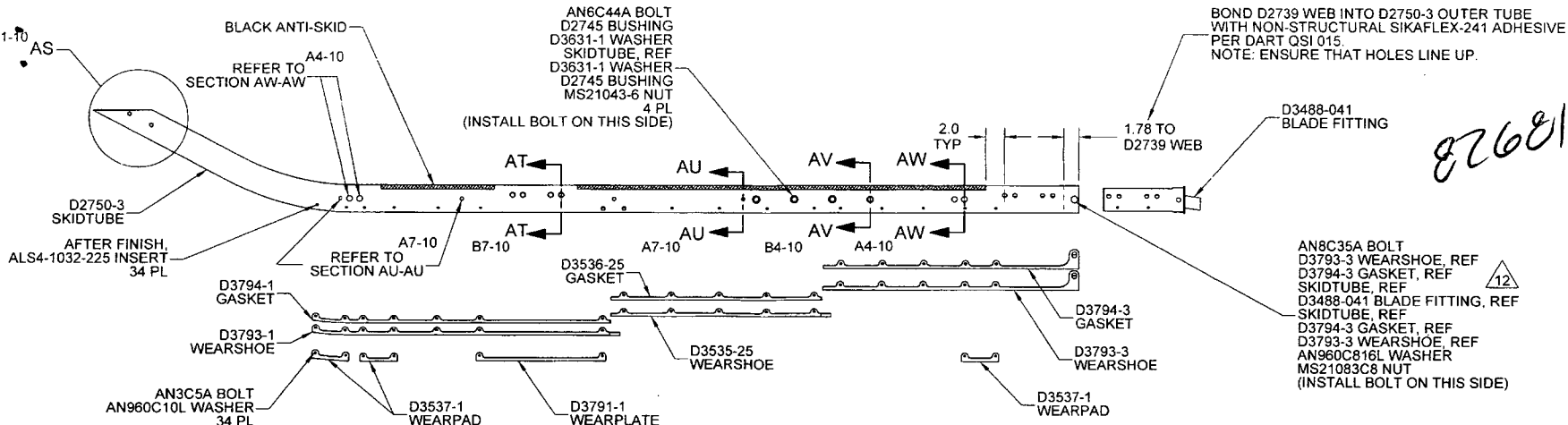
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D8-8
DETAIL AG
SCALE 2X

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MFG. APPR.		SHEET 8 OF 11	
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DATE	08.07.16	NTS	

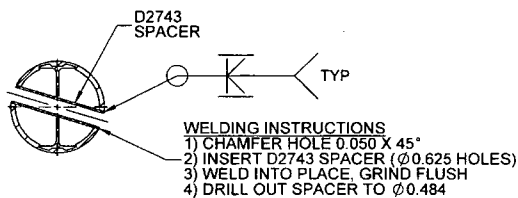
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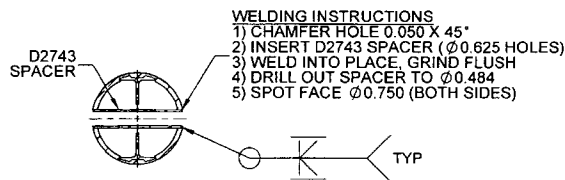
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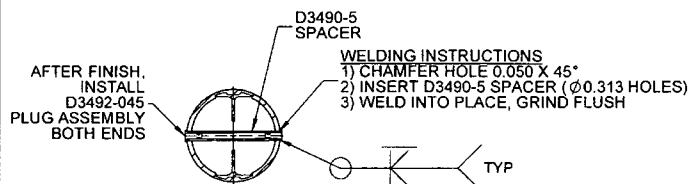
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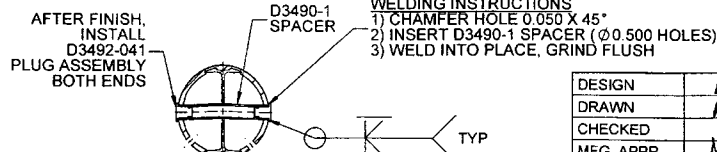
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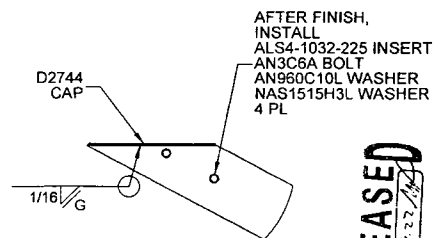
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SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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2018-08-27

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NO. 289

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 81400
Part number: A350-636-016
Description: Shielding
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier David Newell Date of Test Coupon 12.04.17

Welder Barclay Elliott Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld